

Work Order ID 50923

July 27, 2009 7:27:06 AM



Page 1

Item ID: D3516-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Basket Base Assembly (A119)

Start Date: 7/27/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3516	Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut rib D3516-1 as per dwg D3516 2-Cut rib D3516-3 as per dwg D3516 3-Cut rib D3516-5 as per dwg D3516 4-Cut rib D3516-7 as per dwg D3516 15-Cut rib D3516-15 as per dwg D3516 6-Cut rib D3516-9 from D3166-1 (4) using DT8365 jig

SAD 0907-27

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg D3516

PD 09.08.04

120

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.08.04

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Page 2

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Start Date: 7/27/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	2) 6 09.08.04			40 6			
140 Large Fab Large Fab	Large Fab Memo	0.00 0.00				10 09.08.05			
150 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00	Cpl 09.08.06						

Work Order ID 50923








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Item ID: D3516-041 Accept  Setup Start 
Revision ID: C Stop 
Item Name: Basket Base Assembly (A119)
Start Date: 7/27/09 Start Qty: 1.00  Cust Item ID:
Required Date: 8/07/09 Req'd Qty: 1.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	=> S orlos/b6			(X)	0		
170  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo M112260 1ST COAT: <input type="checkbox"/> START TIME: 1:50pm <input type="checkbox"/> OVEN TEMPERATURE: 4000°F <input type="checkbox"/> FINISH TIME: 2:20pm ***** 2nd coat if necessary ***** 2:40pm <input type="checkbox"/> 2ND COAT: <input type="checkbox"/> START TIME: 3:10pm <input type="checkbox"/> OVEN TEMPERATURE: 4000°F	0.00 0.00	* PRESSURE WASH * 09-08-06 (X) JH						
180  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	=> S orlos/b4			(X)	0		

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Stop



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Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

PAP 50921

0.00

Packaging

09/08/20 (1)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/24

MF 09-08-21

Picklist Print

July 27, 2009 7:27:05 AM

Work Order ID: 50923

Parent Item: D3516-041RevC

Parent Item Name: Basket Base Assembly (A119)


Start Date: 7/27/09

Required Date: 8/07/09

Comments:


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			100	Each	11.0000	2.0000			
												
Basket Hinge												


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	15	
48443	9	
50024	6	

1 Cpl 09.07.28
1 Cpl 09.07.28

D2327-3RevD		Manufactured	No			100	Each	64.0000	2.0000			
												
Spacer Bushing												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Premier		
Mezz	70	
44274	61	
44365	9	

2 Cpl 09.07.28

D2581RevA1		Manufactured	No			100	Each	15.0000	2.0000			
												
Mounting Bracket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	23	
46086	2	
48428	21	

2 Cpl 09.07.28

Picklist Print

July 27, 2009 7:27:05 AM

Work Order ID: 50923

Parent Item: D3516-041RevC

Parent Item Name: Basket Base Assembly (A119)


Start Date: 7/27/09

Required Date: 8/07/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3166-1RevA1		Manufactured	No			100	Each	7.0000	4.0000			
 Basket Hoop												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

7

50172

X

7

D3442-1RevA

Manufactured

No

100

Each

16.0000

2.0000

Shim

50570

X3

X1

SAD 09-07-29

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

20

46767

1

47074

7

50023

12

D3516-11RevC

Manufactured

No

100

Each

15.0000

6.0000

Clevis

2Cpl 09.07.28

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

15

45714

15

6 Cpl 09.07.28

Picklist Print

July 27, 2009 7:27:05 AM

Work Order ID: 50923



Parent Item: D3516-041RevC



Parent Item Name: Basket Base Assembly (A119)

Start Date: 7/27/09

Required Date: 8/07/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3516-13RevC

Manufactured

No

100

Each

73.0000

4.0000



Clevis

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

73

45564

34

45565

39

4 Epl09.07.28

D3725-1RevA

Manufactured

No

100

Each

3.0000

2.0000



Hoop

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

45575

3

B50939



2 Epl09.07.28

Picklist Print

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Work Order ID: 50923

Parent Item: D3516-041RevC

Parent Item Name: Basket Base Assembly (A119)

Start Date: 7/27/09

Required Date: 8/07/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	482.5287	60.0000			
Expanded Metal Flat SS												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 482.5287065

108152 90

110134 6.7

110292 14.4

110629 14.41

110861 21.18

110992 0.58

111444 17.79

111630 27.15

111956 6.335517

112147 283.983189

M304TS0.750W.065

Purchased

No

140

f

407.9338

53.3158

304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT 407.9338137

111148 0.484

111432 0.44

111885 1.5682

112051 0.75747369

112263 404.68414

EVD BAR SCRAP

Shop Packet Print

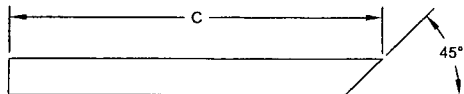
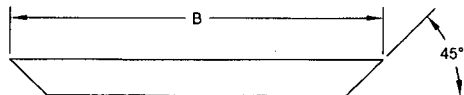
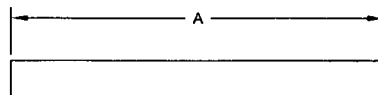
60 SAN 09-07-27 (at)

32.5584 09/07/27
2.8 B 112263

July 27, 2009 7:27:05 AM

PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	LENGTH C	DESCRIPTION
D2232-3	2	N/A	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	N/A	BUSHING
D2581	2	N/A	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	N/A	SHIM
D3516-1	2	---	102.00	---	RIB
D3516-3	2	---	---	2.70	RIB
D3516-5	8	26.75	---	---	RIB
D3516-7	3	45.50	---	---	RIB
D3516-9	4	N/A	N/A	N/A	RIB (MAKE FROM D2235-3)
D3516-11	6	N/A	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	N/A	CLEVIS
D3516-15	2	---	---	19.32	RIB
D3725-1	2	N/A	N/A	N/A	HOOP



D3516-041 BASKET BASE ASSEMBLY NOTES:

1) MATERIAL:

FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL

(REF. DART SPEC. M304TS0.750W.065)

MESH - 3/4-16F EXPANDED STAINLESS STEEL

(REF. DART SPEC. M304EX0.75-16F)

2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 75 lbs

8) WELDING: PER DART QSI 004

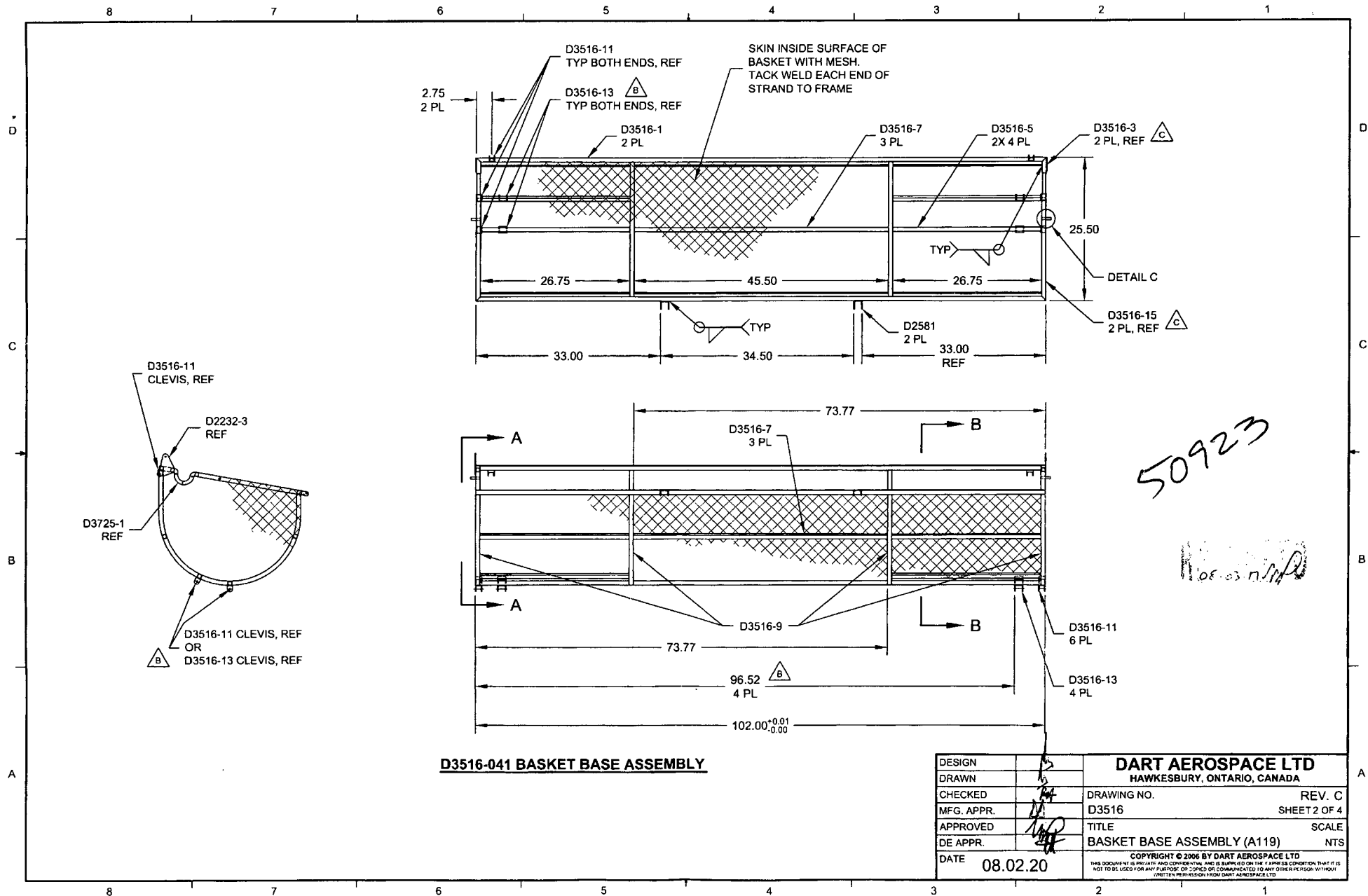
4/0
50923

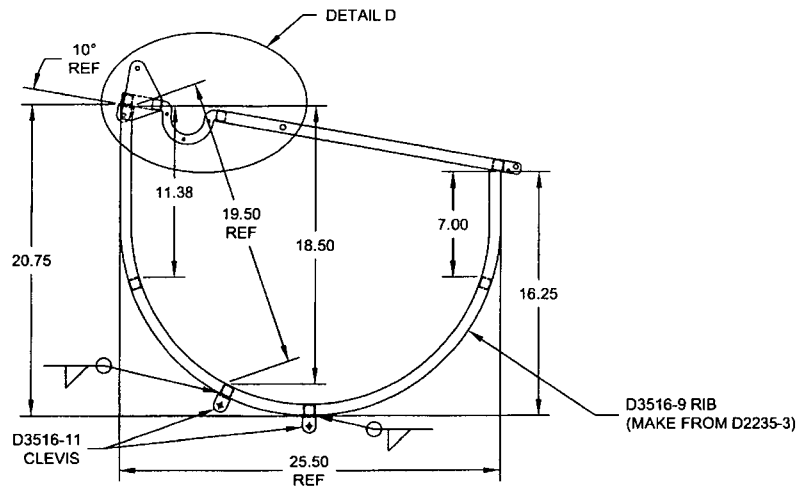
C	ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST	MB	08.02.20
B	ADD QTY.(4) D3516-13; QTY.(6) D3516-11 WAS QTY.(1) SEE TR-D119-756-1 REV. A	MB	06.07.25
A	NEW ISSUE	MB	06.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.02.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

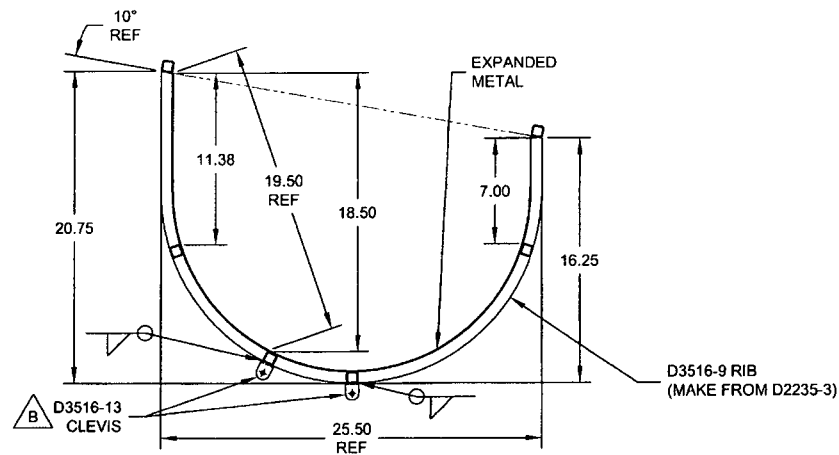
DRAWING NO. REV. C
D3516 SHEET 1 OF 4
TITLE SCALE
BASKET BASE ASSEMBLY NTS

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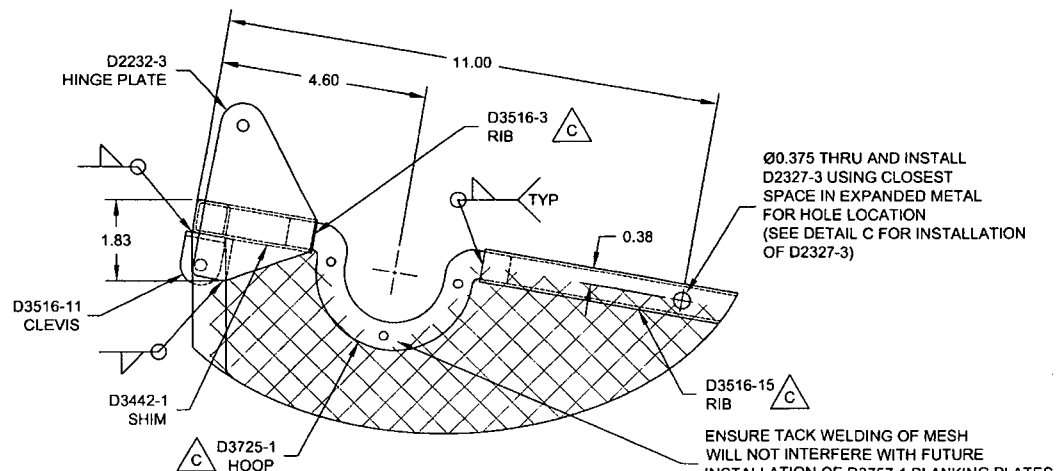




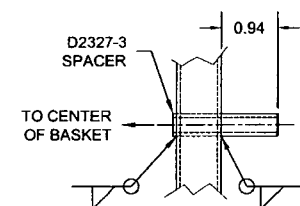
SECTION A-A: END RIB DETAIL
(MESH NOT SHOWN FOR CLARITY)
TYP BOTH ENDS



SECTION B-B: CENTER RIB DETAIL
2 PL



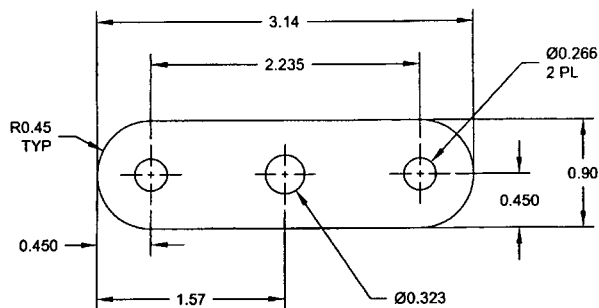
DETAIL D: HOOP & HINGE PLATE DETAIL
FRONT SHOWN, BACK SIMILAR
SCALE 3X



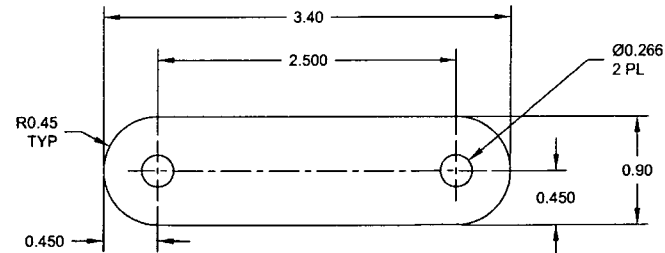
DETAIL C: SPACER INSTALLATION
SCALE 4X

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3516 SHEET 3 OF 4
APPROVED		TITLE SCALE
DE APPR.		BASKET BASE ASSEMBLY NTS
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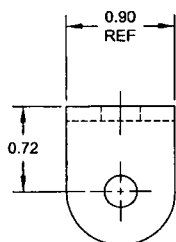


1 D3516-11F CLEVIS FLAT PATTERN

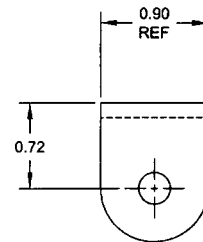
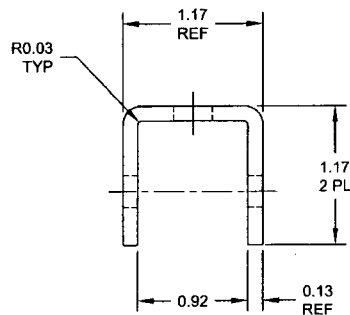


1 D3516-13F CLEVIS FLAT PATTERN

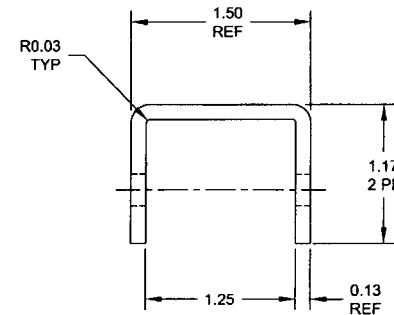
50923



D3516-11 CLEVIS BENDING DETAIL
(MAKE FROM D3516-11F)



D3516-13 CLEVIS BENDING DETAIL
(MAKE FROM D3516-13F)



D3516-11/-13 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs
D3516-13 = 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (A119) NTS	
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